

Date: Monday, 2/5/2007 10:45:37 AM  
 User: Kim Johnston

## Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING
Job Number	: 30638		
Estimate Number	: 12702		
P.O. Number	: N/A	Part Number	: D35527
This Issue	: 2/5/2007	Drawing Number	: D3552 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: N/A	Material	: N/A
Written By	:	Due Date	: 2/12/2007
Checked & Approved By	: <u>1020205</u>	Qty:	75
Comment	: Est Rev: A New Issue 06-11-13 EC	Um:	20
		Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 3039 C207102105  
 Purchase Part Number: B8-220-530-70N  
 Supplier: LS Technologies  
 Certificate of conformity is required

(20)

2.0	B822053070N	CARBON STEEL GAS SPRING
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 CARBON STEEL GAS SPRING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure certificate of conformity is attached

Expiry 10/2/12 (20) AD

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK



Test for correct pressure


5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: \_\_\_\_\_

Expiry 7/2/14 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/02/14	3	split w/o for B/O only 20 rec'd 07/02/12	CY	07/02/13	20		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 07/02/14

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 2/5/2007 10:45:38 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 30638

Part Number: D35527

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

207102/14

Job Completion



U 07-02-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

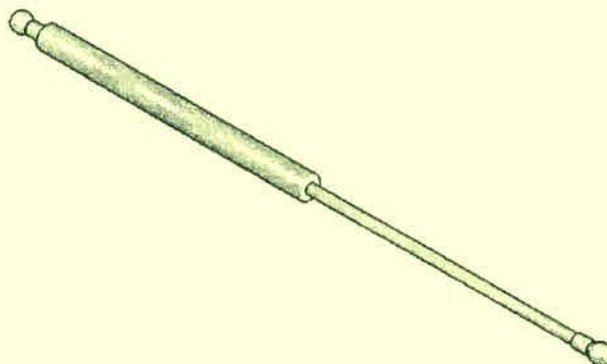
NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3552</b>	REV. B SHEET 1 OF 1
DATE <b>06.09.15</b>		TITLE <b>GAS SPRING</b> SCALE 1:1	
REV	DATE	DESCRIPTION	
A	06.09.15	NEW ISSUE	
B	06.10.24	ADD D-3552-7/-9; UPDATE DESC. D3552-1/-3/-5	

## SPECIFICATION CONTROL DRAWING

DART P/N	STROKE (mm)	EXTENDED LENGTH (mm)	FORCE (N)	END FITTING	MATERIAL	LS TECHNOLOGIES P/N
D3552-1	220	530	70	10 mm SS BALL SOCKET	CARBON STEEL	C8-220-530-70N
D3552-3	200	490	200	10 mm SS BALL SOCKET	CARBON STEEL	C8-200-490-200N
D3552-5	175	430	150	10 mm SS BALL SOCKET	CARBON STEEL	<del>C8-175-430-150N</del>
D3552-7	220	530	70	10 mm NYLON BALL SOCKET	CARBON STEEL	B8-220-530-70N
D3552-9	200	490	200	10 mm NYLON BALL SOCKET	CARBON STEEL	B8-200-490-200N



**D3552-X GAS SPRING**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *30638*

**RELEASED**  
*06.12.22*

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### **Certificate of Compliance**

**Re: Your PO# 3039**

This is to certify that the merchandise listed below meets specifications as required by your order.

B8-220-530-70N Carbon steel Gas Spring - 20 pieces

**This product is ROHS compliant**

**We certify no mercury was used in the manufacture of this order.**

LS Technologies Inv # 3470

Yours Truly  
L S Technologies Inc Canada

A handwritten signature in blue ink, appearing to read "Nolan Fehr", written over a horizontal line.

Nolan Fehr

